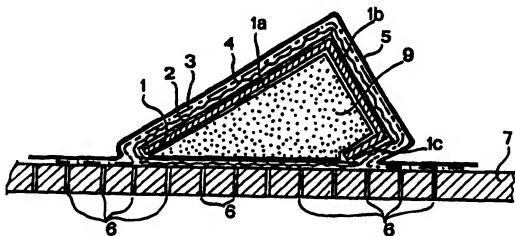




INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B44C 1/17, B41M 3/12, 5/035		A1	(11) International Publication Number: WO 96/29208
			(43) International Publication Date: 26 September 1996 (26.09.96)
(21) International Application Number: PCT/EP96/00656		(81) Designated States: AL, AM, AT, AU, AZ, BB, BG, BR, BY, CA, CH, CN, CZ, DE, DK, EE, ES, FI, GB, GE, HU, IS, JP, KE, KG, KP, KR, KZ, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TR, TT, UA, UG, US, UZ, VN, ARIPO patent (KE, LS, MW, SD, SZ, UG), Eurasian patent (AZ, BY, KG, KZ, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).	
(22) International Filing Date: 15 February 1996 (15.02.96)			
(30) Priority Data: MI95A000570 22 March 1995 (22.03.95) IT			
(71) Applicant (for all designated States except US): VERNICIATURA INDUSTRIALE VENETA S.P.A. [IT/IT]; Via Costeggiola, I-37030 Cazzano di Tramigna (IT).		Published With international search report.	
(72) Inventor; and			
(75) Inventor/Applicant (for US only): FENZI, Giancarlo [IT/IT]; Via Costeggiola, I-37030 Cazzano di Tramigna (IT).			
(74) Agent: TRUPIANO, Roberto; Brevetti Europa S.r.l., Piazza Bernini, 6, I-20133 Milano (IT).			

(54) Title: PROCESS FOR MAKING DECORATED, EXTRUDED, PROFILED ELEMENTS



(57) Abstract

A process for the production of extruded profiles and shaped sheets, variously decorated, especially from aluminium alloy to be used in the building field, for domestic appliances and the like, comprising the steps of preliminary preparation of the surfaces of the article (1), the application of preliminary painting cycles or other surface treatments, the wrapping of the article with a transfer support (2) carrying the decorations wished, the covering of the part so wrapped within a membrane (5) of rubber or the like and the creation of vacuum through holes (6) between the membrane and the piece covered by the same, on prior interposition of means (3) suitable to ensure the flow and the exhaust of the air so as to cause the adhesion of the support to the shape of the article, as well as the possible interposition of yielding means (4), suitable to equalize the pressure exercised by the membrane and lastly the heating for the transfer of the pattern and the polymerization of the colours.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AM	Armenia	GB	United Kingdom	MW	Malawi
AT	Austria	GE	Georgia	MX	Mexico
AU	Australia	GN	Guinea	NE	Niger
BB	Barbados	GR	Greece	NL	Netherlands
BE	Belgium	HU	Hungary	NO	Norway
BF	Burkina Faso	IE	Ireland	NZ	New Zealand
BG	Bulgaria	IT	Italy	PL	Poland
BJ	Benin	JP	Japan	PT	Portugal
BR	Brazil	KE	Kenya	RO	Romania
BY	Belarus	KG	Kyrgyzstan	RU	Russian Federation
CA	Canada	KP	Democratic People's Republic of Korea	SD	Sudan
CF	Central African Republic	KR	Republic of Korea	SE	Sweden
CG	Congo	KZ	Kazakhstan	SG	Singapore
CH	Switzerland	LI	Liechtenstein	SI	Slovenia
CI	Côte d'Ivoire	LK	Sri Lanka	SK	Slovakia
CN	Cameroon	LR	Liberia	SN	Senegal
CM	China	LT	Lithuania	SZ	Swaziland
CS	Czechoslovakia	LU	Luxembourg	TD	Chad
CZ	Czech Republic	LV	Latvia	TG	Togo
DE	Germany	MC	Monaco	TJ	Tajikistan
DK	Denmark	MD	Republic of Moldova	TT	Trinidad and Tobago
EE	Estonia	MG	Madagascar	UA	Ukraine
ES	Spain	ML	Mali	UG	Uganda
FI	Finland	MN	Mongolia	US	United States of America
FR	France	MR	Mauritania	UZ	Uzbekistan
GA	Gabon			VN	Viet Nam

PROCESS FOR MAKING DECORATED, EXTRUDED, PROFILED ELEMENTS

5

DESCRIPTION

This invention relates to a process and the relevant apparatus for the realization of articles or parts from metal, painted and/or variously decorated, particularly from aluminium alloy, comprising extruded or drawn semifinished products, also of large size, or bent or shaped sheets, even of large size, in particular to be used in building and in the field of the production of domestic appliances, such as refrigerators, washing machines and the like.

More particularly, said process allows to obtain surface finishings which reproduce accurately the aspect of various materials, such as the grains of wood and veins of marble or other patterns, as well as to transfer on the part and/or the surface of the extruded or drawn profiles or the shaped sheets any ornamental pattern, even a complicated one, without deformations or defects of the same pattern.

This invention also relates to an apparatus which allows to realize said decorated articles.

As is known, the processes of the known art for the realization of the decoration on metals involves realization difficulties and complexities due to the fact

that they require more or less automatized installations which operate on the flat surface of strips or sheets.

- Besides, other processes and apparatuses are known for
- 5 the realization of one-colour painting of metal articles, for instance parts or profiles from aluminium alloy, which consist, for instance, in electro-colouring processes, very complicated and expensive, or processes based on the technique of the transfer of a
- 10 multi-colour pattern from a support carrying the pattern to a flat surface, from metal or fabric or other materials, by a contemporaneous action of pressure and temperature, carried out sometimes continuously by means of heated calenders.
- 15 Processes and associated apparatuses are also known which allow the realization of multi-colour and complicated decorations on articles of various type and having also a surface other than flat by the technique of the transfer of a pattern from a flexible support to
- 20 the whole surface of the article by ink sublimation. As is known, such technique consists in wrapping the article with a support comprising the sublimable decoration, usually from paper, in introducing the article wrapped in the paper support into a container made up
- 25 by two elastically deformable membranes fixed to two substantially rectangular frames hinged to one another, in making the vacuum in said container so that the

flexible membranes adhere to the article, crushing the support against the surface of the articles. The pressure and the heat may be obtained also in an oil bath oven. In this case, the article to be decorated, suitably wrapped by the decoration transfer support, is introduced in the oil bath oven, protected by an envelope or bag from elastically deformable, high temperature resistant material.

Processes of this type and the associated apparatuses, such as for instance the one described in FR 2203321 (VILLEROY), EP 544603 (CLAVEAU), EP 451067 (CLAVEAU) and EP 606189 (CLAVEAU), allow however to realize multi-colour or anyhow complicated decorations only on small size articles, such as for instance cans, canisters, china articles and the like, but not on large size articles, such as extruded profiles of a length up to 20 meters, bent or shaped sheets and the like.

Therefore, object of this invention is to provide a process and the associated apparatus for the realization of open or closed section profiles from aluminium alloy or other metals, of large size, for instance extruded pieces having a length up to about 20 meters and rigid bent and shaped sheets, so decorated as to carefully reproduce the aesthetic effect of the various materials, such as wood, marble or the like, or anyhow showing throughout the surface or part of the same any ornamental pattern (floral, geometrical or other ones),

however complicated and elaborated.

A further object of this invention is to provide extruded profiles for building, shaped sheets for domestic appliances, etc. variously decorated on the surfaces
5 which remain on sight, even with complicated patterns, substantially free from defects, disuniformities of the pattern and the like.

Another object of the invention is to provide a process comprising particularly simple and highly reliable
10 working steps, as well as the associated apparatus, such as to lead to finished articles suitable to be widely used in many and different sectors, particularly in building and in the field of furniture, in the field of domestic appliances and the like.

15 These and still other objects, which will appear more clearly from the following description, are reached by a process for the realization of large size articles such as extruded or drawn semifinished products, bent and shaped sheets and the like, having also indenta-
20 tions, recesses and grooves, painted and/or variously decorated, particularly from aluminium alloy, utilizing the technique of the transfer of one-colour or multi-colour patterns or figures, reproduced on a paper transfer support or the like, by a combined action of
25 pressure and temperature, which process comprises, according to this invention, the following steps:

- submitting the raw article to be decorated, consi-

sting of profiles of a length up to 20 meters or of bent or shaped sheets, to usual operations of surface preparation, such as cleaning, degreasing, chemical and/or electrolytic conversion, then

5 - submitting it to one or more preliminary painting cycles, realizable with fluid or powder paints, carrying out a first operation with paints of a prefixed colour and such as to constitute a primer coat, and a possible subsequent operation with transparent paints
10 to avoid phenomena of diffusion with the colours of the transfer support, or, in the case of aluminium and its alloys, submitting it to anodization, either colourless or coloured, then

- after the complete polymerization of said painting
15 cycles or at the end of said anodization, carrying out the wrapping of the article or the covering of the surfaces of the article to be decorated, with said transfer support, and then

- covering the article already wrapped in said support
20 with a sheath or membrane from elastically yielding impermeable material, such as rubber or the like, flat or so shaped as to substantially adjust to the shape of the article, then

- creating the vacuum between said article wrapped in
25 said support and said membrane, so as to cause the transfer support to uniformly adhere to the form of the article, and lastly

- submitting the so treated article to a heating action variable up to about 280°C, for a time ranging from about 30 seconds to 30 minutes, to perform the transfer and the polymerization of the final colours from the transfer support to the article.

More particularly, according to this invention, between said article wrapped in said support and in said sheath or membrane from elastically yielding impermeable material, a means is interposed from flexible, air-permeable material, such as large weft fabric, gauze or the like, suitable to create thin channels between the article wrapped in the support and the impermeable sheath or membrane, allowing in this way the complete and uniform exhaust of air during the stage of vacuum creation, avoiding disuniformities in the adhesion of the sheath to the article, the formation of air bubbles and the like.

In fact, it has been noticed that the interposition of the means from flexible, air-permeable material according to this invention allows to realize articles provided with various and complicated decorations, substantially free from deformations of the pattern, presence of non decorated zones or zones with poorly engraved decorations, also when the article is of large size, such as for instance an extruded profile of a length up to 20 meters, a shaped and bent sheet, such as the door of a refrigerator, etc.

Always according to this invention, between said article wrapped in said support and said elastically yielding membrane, a means is interposed from flexible permanently yielding material, such as crêpe paper or the like, suitable to unify and equalize the pressure exercised by said membrane on the surfaces of the article under the action of the vacuum. In fact, it has been noticed that the interposition of said permanently yielding means, such as crêpe paper or the like, allows to realize substantially without deformations, twists, fadings or the like, any pattern and decoration, however complicated and/or with nuances, contrasts, etc., even on the most difficult points of the surface of the article, such as those in correspondence of the edges.

Besides, always according to this invention, to ensure the adhesion of the inked support to the article to be decorated and/or to prevent deformations of the open profile articles, counter-mouldings or pads are applied within said indentations or recesses, between said transfer support and said membrane before creating the vacuum, if one wishes to decorate also the internal surface of said indentations, or directly in touch with the surface of said recesses, if one does not wish to decorate the internal surface of said recesses, as for instance in the case of the internal surface of a bent sheet to be used for a refrigerator door, in which case, as is obvious, it is useless to decorate the

internal face of the sheet, as the latter will be entirely covered by insulating material and the counter-door. In the above case, the counter-moulding is utilized for the purpose of countering the stresses
5 ensuing from the creation of vacuum, preventing in this way deformations in the parts to be decorated. The counter-moulding or pad may be realized from any rigid or semi-rigid material that can withstand the working temperatures. Materials such as silicone rubber, wood,
10 aluminium, steel, etc., can be advantageously utilized. More particularly, said final heating action is carried out by means of several infrared lamps or said heating is carried out within a tunnel-oven or the like with hot air circulation obtained by any energy source.
15 Besides, said final heating temperature is preferably maintained for a time comprised between 30 seconds and 30 minutes.

The process subject matter of the invention utilizes for the application on profiles inks suitable also for
20 outdoor exposure.

After the suitable and known operations of preparation of the surfaces to be decorated, one or more preliminary painting cycles are performed, which are obtainable with either fluid or powder paints, with the aim of
25 obtaining a coat of primer and a possible transparent layer to prevent phenomena of diffusion with the colours of transfer from the support. Besides, for the

practical realization of the process according to this invention, various apparatuses can be used which allow to decorate open or closed section profiles of lengths up to about 20 meters, as well as bent and shaped sheets whose size is fit for constituting parts of furniture, domestic appliances, such as refrigerator doors and the like.

An apparatus for the realization of profiles and variously decorated shaped sheet according to this invention comprises:

- a bench of a length up to 20 m, on which the article rests which has to be decorated, suitably pretreated (cleaned, degreased and already treated with one or more preliminary paint coats or submitted to anodization, either colourless or coloured), and on which said article is prepared by wrapping it with the transfer support, the permeable means and possibly the permanently yielding means;
- a table of a length equal to the length of said bench, provided with a plurality of through-holes, on which said wrapped article is transferred and positioned;
- a covering means comprising at least a sheath or membrane from elastically yielding impermeable material to be positioned on said wrapped article resting on said table;
- a device to create the vacuum between said membrane

and said drilled table through said holes, so that said membrane adheres and exerts a pressure on said wrapped article;

5 - heaters located above said drilled table, associated to ventilation and air circulation means, positioned in a special hood.

More particularly, said heaters may advantageously comprise, for instance, a battery of infrared lamps in a room with ventilated air.

10 Besides, said drilled table may be horizontally translatable and/or said hood liftable so as to make easier the access to the zone concerned by the drilled table in case of particularly delicate workings.

The elastically yielding membrane is substantially
15 formed by a blanket from rubber or other elastic and heat-resistant material, which is laid on the wrapped article to be decorated and which adheres to the same thanks to the vacuum created through the holes. The membrane may be entirely free, or, for the sake of
20 convenience, it may be fixed to the table along one of its sides, or along an edge of the hood, etc.

According to a variant of this invention, said covering means may be formed by a horizontally translatable base, comprising a first rigid frame to which an elastic or
25 semi-rigid table is fixed, on which table the wrapped article rests, and an upper elastically yielding envelope fixed to a second frame, liftable or book-like

openable above said base, the vacuum creation being obtained between said base and said upper envelope through through-holes obtained in said first or said second frame and connected to said device for the
5 creation of vacuum.

Said covering means may be constituted by a tubular flexible bag of a length slightly longer than the length of the article to be decorated, within which there is wrapped the article covered with the support
10 to be decorated, the vacuum being obtained from the end of said tubular bag by means of the vacuum creation device.

Further characteristics and advantages of this invention will be better stressed by the following detailed
15 description, made with reference to the attached drawings, which have only an indicative and non limitative purpose, wherein:

Figs. 1 and 2 show schematically the section of an article wrapped in the various preparation means and covered by the elastically yielding membrane, ready to
20 be submitted to the heating action;

Fig. 3 shows schematically the section of another type of covered article resting on the translatable base, according to the variant of this invention and ready to
25 be submitted to heating;

Fig. 4 shows schematically the section of an apparatus suitable to carry out the decoration process according

to the invention on various articles, such as extruded rods or profiles or shaped sheets of different sizes and of a length up to 20 meters;

Fig. 5, always schematically and in section, shows a
5 variant of the apparatus of Fig. 4.

With reference to Fig. 1, article 1, constituted by a "C"-shaped extruded profile from alumium alloy, to be generically utilized in the building field, is wrapped in the transfer support 2, in the large weft cloth 3
10 suitable to create the channels for the flow and exhaust of air, and in the permanently yielding means 4, formed by crêpe paper, particularly suitable, as said, when one wishes to decorate adjoining edge surfaces, as are in this case surface 1a, 1b and 1c.

15 The article is then covered with the elastically yielding membrane 5 which adheres perfectly to all the parts of the articles which are to be decorated, thanks to the vacuum created between membrane 5 and table 7 through holes 6 obtained in table 7 and connected to
20 the device for the creation of vacuum 8. A counter-moulding 9 may be inserted in the recess of the hollow profile, wherein the vacuum creation may cause deformations in the piece to be decorated, acting in this case as a reinforcement.

25 Fig. 2 shows the "C"-shaped profile 1, provided with counter-moulding 9 applied in the recess of the same profile, when one wishes to decorate also its internal

faces; in this case, the counter-moulding 9 acts as a pad besides as a reinforcement.

Fig. 3 shows a variant of the invention: the cylindrical extruded profile 10, wrapped in the transfer support 11 and in the large weft cloth 12 is placed on the
5 elastic table 13 fixed to the first hollow frame 16; the upper envelope 14, fixed to the hollow frame 15 covers the profile wrapped in the support and the cloth and adheres to the same support thanks to the vacuum
10 created through holes 17, which, through recess 17a of the frame and holes 17 b, are connected with the device for the creation of vacuum 8, through channels 18. In this way, thanks to recess 17a provided in the frame, a perfect uniformity is obtained in the creation of
15 vacuum, which also contributes to prevent defects in the transfer of the decoration, when the article is complicated or long. In the example of Fig. 3, the interposition of crêpe paper, i.e. of a permanently yielding means, is not necessary, as the surface of the
20 profile has no edges.

Fig. 4 shows an apparatus suitable to realize the decorated article according to the invention. Such apparatus comprises bench 19 on which article 1 is wrapped in the transfer support, the cloth, etc., the
25 latter being not represented. From bench 19, the wrapped article is transferred to table 7 and covered with the membrane or sheath 5. Then, through device 8,

formed by a pump or the like, and through holes 6, the vacuum is created, so that membrane 5 adheres to the wrapped article for its whole length. The heat necessary for the transfer of the decoration from the support to the article is supplied by heaters 20 located above the table, in hood 21. There are also provided means 22, formed by fans or the like, which ensure the circulation of air for the whole length of the hood and uniformly along the whole article. For more use easiness, hood 21 may be liftable and also the table on which the article rests may be horizontally translatable.

The apparatus shown in Fig. 5 comprises a semi-rigid base 13 anchored to frame 16, translatable in the position 13a, of a length greater than the length of the profile or the sheet, and with an upper envelope 14 fixed to a hollow frame 15, liftable or book-like openable, made from a flexible material (rubber or the like) which retracts and perfectly adheres to the pieces on prior creation of the vacuum with the special device 8. This part of the apparatus slides on rails and is placed inside hot-air oven 21, to carry out the transfer of the colours from the support to the article. Fig. 5 indicates the position for the preparation of the pieces and 13a shows the working position within the apparatus.

Fans 22 provide to the ventilation and air circulation. Said flexible membrane may be constituted by a flexible

tubular bag of a length slightly greater than the length of the article to be decorated, within which there is enclosed the article wrapped in the transfer support, the vacuum being created from the end of said
5 tubular bag by means of device 8, through channel 18.

In practice, it has been noticed that the above described process allows to perfectly transfer the decorations obtained on the support to all the zones, even to the non flat ones, of the profile, which allows to
10 perfectly decorate also profiles having a complicated section and profiles of any size.

Obviously, in the practical realization, structurally and functionally equivalent modifications and variants can be made to the invention as described hereabove and
15 claimed hereafter.

20

25

CLAIMS

1. A process for the realization of large size metal articles such as extruded or drawn half-finished products, bent and shaped sheets and the like, even provided with indentations, recesses, grooves and the like, painted and/or variously decorated, especially from aluminium alloy, utilizing the technique of the transfer of one-colour or multi-colour patterns, decorations or figures, reproduced on a transfer paper support or the like by means of the combined action of pressure and temperature, characterized in that it comprises the following steps:
- submitting the raw article (1) to be decorated, consisting of profiles of a length up to 20 meters or of bent or shaped sheets, to usual operations of surface preparation, such as cleaning, degreasing, chemical and/or electrolytic conversion, anodization, then
 - submitting it to one or more preliminary painting cycles, realizable with fluid or powder paints, carrying out a first operation with paints of a prefixed colour and such as to constitute a coat of primer, and a possible subsequent operation with transparent paints to avoid phenomena of diffusion with the colours of the transfer support, or, in the case of aluminium and its alloys, submitting it to anodization, either colourless or coloured, then
 - after the complete polymerization of said painting

cycles or at the end of said anodization, carrying out the wrapping of the article or the covering of the surfaces of the article to be decorated, with said transfer support (2), and then

5 - covering the article already wrapped in said support (2) with a sheath or membrane (5) from elastically yielding impermeable material, such as rubber, flat or so shaped as to substantially adjust to the shape of the article, then

10 - creating the vacuum between said article wrapped in said support (2) and said membrane (5), so as to cause the transfer support to uniformly adhere to the form of the article (1), and lastly

- submitting the so treated article to a heating action
15 variable up to about 280°C, for a time ranging from about 30 seconds to 30 minutes, to perform the transfer and the polymerization of the final colours from the transfer support to the article.

2. The process according to claim 1, characterized in
20 that between said article (1) wrapped by said support (2) and said sheath or membrane (5) from impermeable elastically yielding material, a means (3) is interposed from air-permeable flexible material such a large weft fabric, gauze or the like, suitable to create thin
25 channels between the article wrapped in the support and the impermeable membrane, causing in this way the complete and uniform exhaust of air in the vacuum

creation stage, avoiding disuniformities in the adhesion of the membrane to the article, the formation of air bubbles and the like.

3. The process according to claim 1, characterized in
5 that between said article (1) wrapped by said support (2) and said elastically yielding membrane (5) a means (4) is interposed from flexible permanently yielding material, suitable to unify and equalize the pressure exercised by said membrane (5) on the surfaces of the
10 article under the action of the vacuum.

4. The process according to claim 3, characterized in that said flexible permanently yielding means (4) is constituted by crêpe paper.

5. The process according to claim 1, characterized in
15 that counter-mouldings or pads (9) are applied within said indentations or recesses, between said transfer support (2) and said membrane (5) prior to the vacuum creation, if one wishes to decorate also the internal surface of said recesses, or directly in touch with the
20 surface of said recess, if one does not wish to decorate the internal surface of said recesses.

6. The process according to claim 1, characterized in that said final heating action is carried out by means of infrared lamps in ventilated air environment, or
25 within a hot air tunnel oven or the like, which hot air is supplied by any induction energy source.

7. The process according to claim 1, characterized in

that said final heating temperature is maintained for a time comprised between 30 seconds and 30 minutes.

8. An apparatus for the realization of the process for the decoration of large size metal articles according to the preceding claims, characterized in that it comprises:

- a bench (19) of a length up to about 20 m, on which an article (1) rests which has to be decorated, suitably pretreated (cleaned, degreased and already treated with one or more preliminary paint coats or submitted to anodization, either colourless or coloured), and on which said article is prepared by wrapping it with the transfer support, the air permeable means and possibly the permanently yielding means;
- a table (7) of a length equal to the length of said bench (19), provided with a plurality of through-holes (6), on which said wrapped article is transferred and positioned;
- a covering means comprising at least a sheath or membrane (5) from elastically yielding impermeable material to be positioned on said wrapped article resting on said drilled table (7);
- a device (8) to create the vacuum between said membrane and said drilled table (7) through said holes (6), so that said membrane adheres and exerts a pressure on said wrapped article;
- heaters (20) located above said drilled table (7),

associated to ventilation and air circulation means (22), positioned in a special hood (21).

9. The apparatus according to claim 8, characterized in that said drilled table (7) is horizontally translatable and/or said hood is liftable.

10. The apparatus according to claim 8, characterized in that said covering means is formed by a horizontally translatable base comprising a first rigid frame (16) associated to an elastic or semi-rigid table (13) on which said wrapped article (10) rests, and by an elastically yielding upper envelope (14) fixed to a second frame (15) liftable or book-like openable above said base (13, 16), the creation of vacuum being obtained between said base and said upper envelope through through-holes (17) provided in said first and/or said second frame (15) and connected to said vacuum creation device (8).

11. The apparatus according to claim 10, characterized in that said first and said second frame are hollow.

12. The apparatus according to claim 8, characterized in that for the treatment of extruded or drawn profiles also of great length a supporting table (13, 16) is provided having a translatable carriage or the like for the profile (10) wrapped in the transfer support and enclosed within or covered by said flexible membrane (14), which carriage, after the vacuum creation stage, is translated into a hot air tunnel oven (21) to carry

out the final transfer of the decorations.

5

10

15

20

25

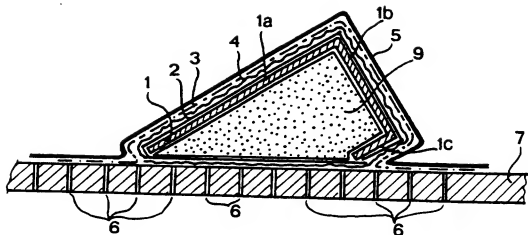


FIG. 1

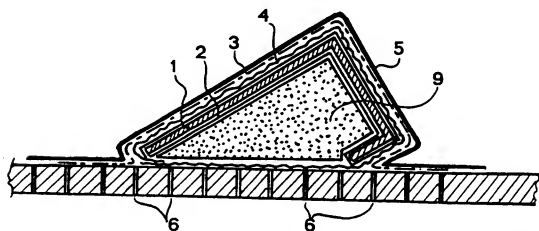


FIG. 2

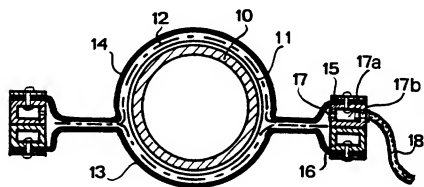
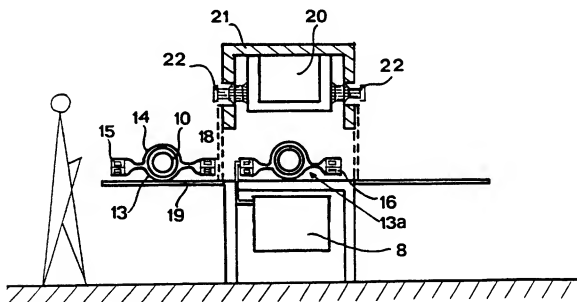
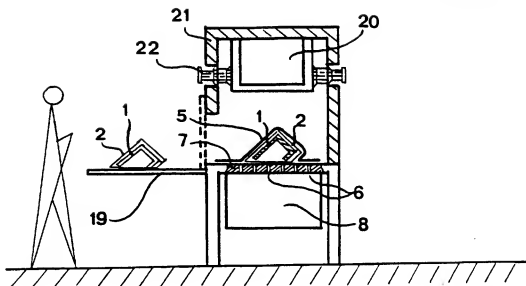


FIG. 3



INTERNATIONAL SEARCH REPORT

Int. Application No
PCT/EP 96/00656

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 B44C1/17 B41M3/12 B41M5/035

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 6 B44C B41C B41M

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP,A,0 641 575 (BLIZZARD GES. M.B.H.) 8 March 1995 see column 1, line 42 - column 5, line 4 ---	1,3,6-9
Y	EP,A,0 451 067 (JEAN-NOEL CLAVEAU) 9 October 1991 cited in the application see column 1, line 1 - column 5, line 15 ---	1,8-12
Y	US,A,4 328 268 (YOSHIHARU TSUJI ET AL) 4 May 1982 see column 1, line 64 - column 3, line 58; examples 1-4 ---	1,8-12
A	US,A,3 340 121 (CARL F. LAWRENCE) 5 September 1967 see column 1, line 1 - column 3, line 23 --- -/-	1,8

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents:

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"A" document member of the same patent family

Date of the actual completion of the international search

20 May 1996

Date of mailing of the international search report

06-06-1996

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentkan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Doolan, G

INTERNATIONAL SEARCH REPORT

Int. Application No
PCT/EP 96/00656

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US,A,3 868 901 (J. VALIELA) 4 March 1975 see column 3, line 1 - column 5, line 16 -----	1,2,8

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No
PCT/EP 96/00656

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
EP-A-641575	08-03-95	DE-C- 4330077	16-03-95
EP-A-451067	09-10-91	FR-A- 2660252	04-10-91
		AT-T- 129200	15-11-95
		CA-A- 2039054	04-10-91
		DE-D- 69113849	23-11-95
		DE-T- 69113849	04-04-96
		ES-T- 2080929	16-02-96
		JP-A- 4226400	17-08-92
US-A-4328268	04-05-82	JP-C- 1070065	30-10-81
		JP-A- 53123214	27-10-78
		JP-B- 55006516	16-02-80
US-A-3340121	05-09-67	NONE	
US-A-3868901	04-03-75	CA-A- 985566	16-03-76
		DE-A- 2359113	13-03-75
		FR-A- 2240114	07-03-75
		GB-A- 1400900	16-07-75
		JP-A- 50037505	08-04-75
		US-A- 3871293	18-03-75
		US-A- 3756165	04-09-73